Date: Wednesday, 6/6/2007 1:38:09 PM
User: Kim Johnston

# Process Sheet

| | | | |
|---|---|---|---|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : 206 EXTRUSION BENDING |
| Job Number | : 32754 | | |
| Estimate Number | : 10311 | | |
| P.O. Number | : N/A | Part Number | : D2620 |
| This Issue | : 6/6/2007   S.O. No. : N/A | Drawing Number | : D2620 REV B |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : N/A   Type : LANDING GEAR | Drawing Revision | : B |
| Previous Run | : 32449 | Material | : N/A |
| | | Due Date | : 6/20/2007   Qty: 20   Um: Each |
| Written By | : | | |
| Checked & Approved By | : KJ 07.06 07 | | |
| Comment | : Est. D 02.07.26   Change Dwg to rev.B; Updated Location RF | | |

**Additional Product**

**Job Number:**

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 1.0 | D26001160 | Extrusion Round 3" 206 |

Comment: Qty.:   1.0000 Each(s)/Unit   Total :   20.0000 Each(s)
Extrusion Round 3" 206
Pick;

| Qty | Part Number | Description | Batch | |
|---|---|---|---|---|
| 1 | D2600-1 | Extrusion Round 3"206 | 30299 | EL 7-6-18 |

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 2.0 | LANDING GEAR 1 | LANDING GEAR RESOURCE 1 |

Comment: LANDING GEAR RESOURCE 1
1-Bend extrusion as per Dwg D2620 usingCNC Bending Machine program 206.A
and Folio Ft008
2- Cut Fwd end of tube as per Dwg D2620

EL 7-8-12

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 3.0 | QC5 | INSPECT WORK TO CURRENT STEP |

Comment: INSPECT WORK TO CURRENT STEP   BE

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 4.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: LG   BE 07-06-14

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 5.0 | QC21 | FINAL INSPECTION/W/O RELEASE |

Comment: FINAL INSPECTION/W/O RELEASE   D 07/06

**Job Completion**

Form: rprocess

**Dart Aerospace Ltd**

## WORK ORDER CHANGES

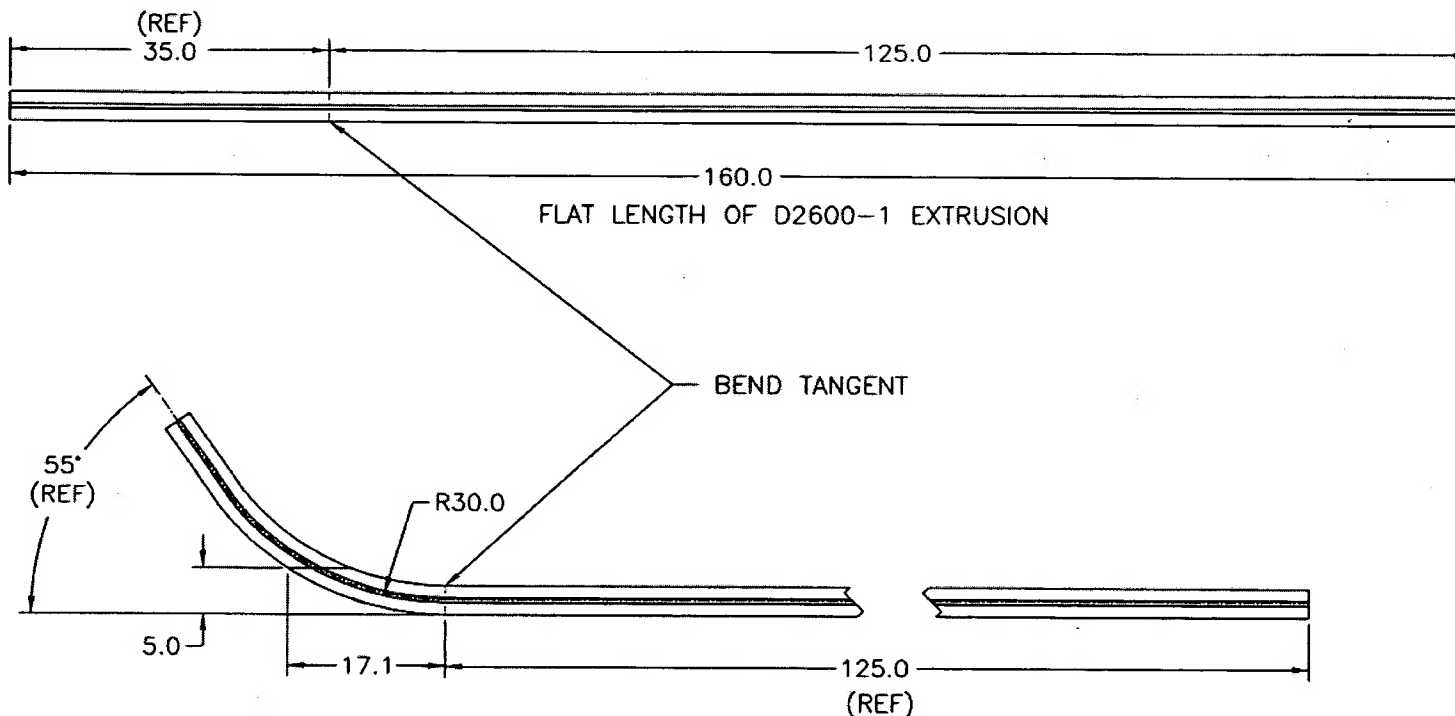| W/O: | | | | | | | |
|------|------|------|------|------|------|------|------|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: _____ Date: 970766

QA: N/C Closed: _____ Date: _____

## WORK ORDER NON-CONFORMANCE (NCR)

| NCR: | | | | | | | | |
|------|------|------|------|------|------|------|------|------|
| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Chief Eng | **Approval** QC Inspector |
| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

# SPECIFICATION CONTROL DRAWING
## 206 SKIDTUBE BENDING

(REF)
35.0

125.0

160.0

FLAT LENGTH OF D2600-1 EXTRUSION

BEND TANGENT

55° (REF)

R30.0

5.0

17.1

125.0 (REF)

## DAMAGE TOLERANCE

1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0 AFTER BENDING.
2. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE.
   NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE.
   DEEPER GOUGES ARE ACCEPTABLE IN THE PORTION OF THE TUBE ABOVE 5.0.
3. TUBE WIDTH SHOULD BE 3.20 ± 0.200 IN THE BEND.
   TUBE WIDTH SHOULD BE 3.200 ± 0.010 IN THE FLAT PORTION OF THE TUBE.
4. TUBE HEIGHT SHOULD BE 3.15 ± 0.200 IN THE BEND.
   TUBE HEIGHT SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE.

NOTE:   ALL DIMENSIONS ARE IN INCHES

**DART**

QA COPY ISSUED

RELEASED
99.04.15 DS

| | DESIGN | | | |
|---|---|---|---|---|
| | CHECKED | | | |
| | DRAWN BY | RF | | |
| | APPROVED | KE | | |
| | DATE | 99.09.10 | | |
| A | | 97.11.07 | NEW ISSUE | |
| B | | 97.09.10 | UPDATE FOR IN-HOUSE BENDING | |

### DART AEROSPACE USA, INC.
FAIRCHILD INTERNATIONAL AIRPORT, WA

| DRAWING NO. | REV. B |
|---|---|
| D2620 | SHEET 1 OF 1 |

TITLE: 206 SKIDTUBE BENDING CONTROL

SCALE 1:20